

Work Order ID 129425

February-09-15 9:03:32 AM

129425

Page 1

Item ID: D4463-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Bottom
 Start Date: 2/09/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 2/16/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4463	D								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg								
6061-063	Prog rev: <u>D</u>								
	Dwg rev: <u>D</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

FEB 26 2015

Work Order ID 129425

February-09-15 9:03:32 AM

129425

Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00			DAS 30 9-89	6			15/03/03
140 *140* QC Quality Control	^{QC5} QC - Inspect dimensions to drawing Memo	0.00 0.00				6			DAS 38 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6	9	15-3-9	DEL

MAR 03 2015

Work Order ID 129425

February-09-15 9:03:32 AM

129425

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									

MAR 10 2015

170	Identify as per dwg & Stock Location: <u>WA3</u>	0.00							DAS 24 9-89
170									
Packaging	Memo	0.00							
Packaging									

MAR 11 2015

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

ML5 1503-12
15.3-12

Picklist Print

February-09-15 9:03:32 AM

Page 1

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129425

Parent Item: D4463-13

D4463-13

Parent Item Name: Tank Bottom

Start Date: 2/09/15

Required Date: 2/16/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	263.1162	2.748	18			

M6061T6S 063

6061-T6 .063 Sheet

DC 15/02/26

Location

Loc Qty

Loc Code

MAT021

263.1162

M128941

11.132

M129845

30.0743

M130096

25

M130745

24.0799

M131322

86.83

M131383

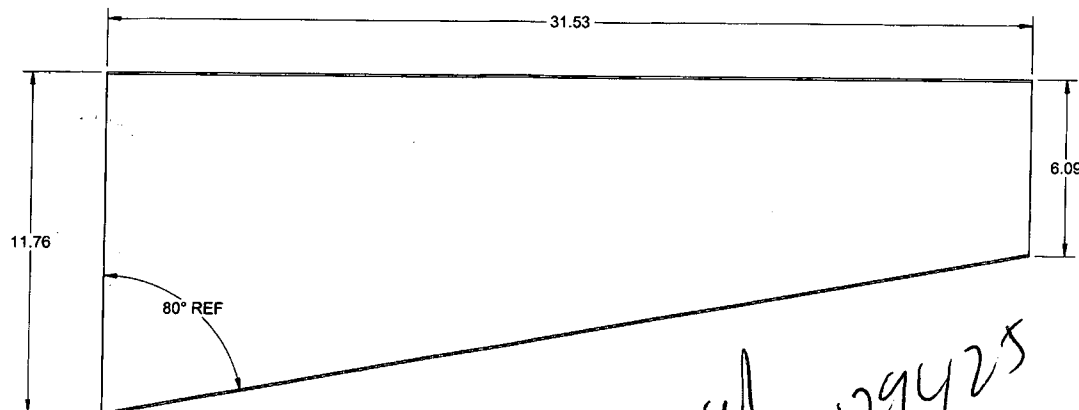
86

131653

13.75

R0.19
TYP

0.50
TYP



u/o 129425

D4463-13 TANK BOTTOM

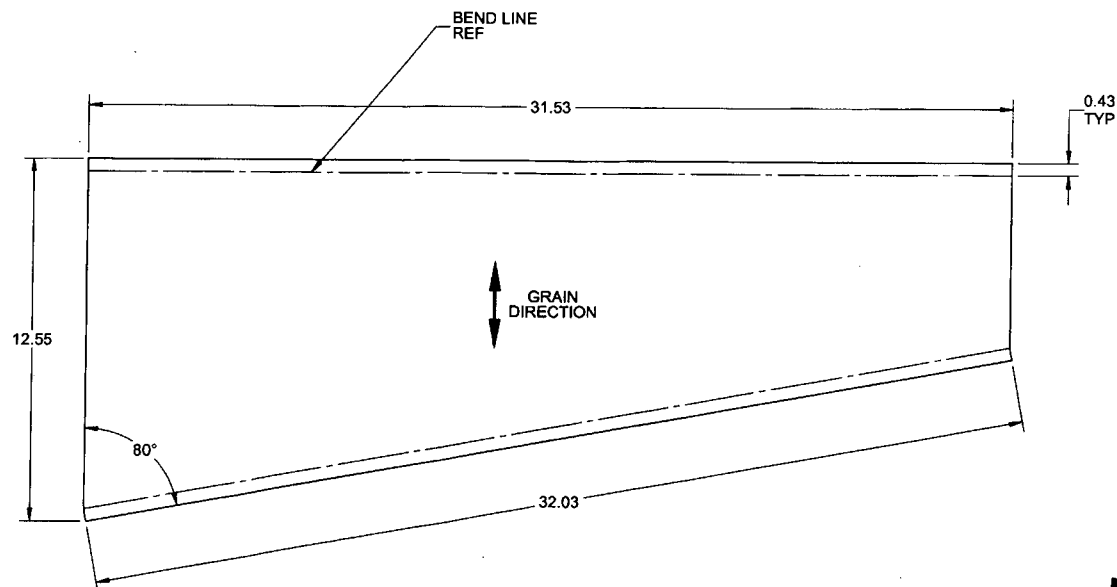
NOTES:

- 1) MATERIAL: MADE FROM D4463-13F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.88 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO. D4463	REV. D
MFG. APPR.	JLM	TITLE AUX TANK	SHEET 13 OF 14
APPROVED	MP		SCALE
DE APPR.	DS		NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2014-06-11



D4463-13F FLAT PATTERN

RELEASED
2014-06-11

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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MFG. APPR.	JLM	D4463	SHEET 14 OF 14
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DE APPR.	DS	AUX TANK	NTS
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